

Date: Thursday, 01/05/2008 4:16:41 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLATE
Job Number : 38971	
Estimate Number : 10424	
P.O. Number :	Part Number : D33031
This Issue : 01/05/2008 S.O. No. :	Drawing Number : D3303 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 29951	Material :
Written By :	Due Date : 10/05/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JUL 08.5.02</u>	
Comment : Est:A 04.09.07 New issue KJ/JLM Est Rev:B 06-06-28 Now On Waterjet JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S032	2024-T3 .032 sheet
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**Comment:** Qty.: 0.3719 sf(s)/Unit Total: 3.7191 sf(s)Material: 2024-T3 (QQ-A-250/4) 0.032" thick
(M2024T3S.032)Batch: 105555 HB 8-5-7

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3303

Dwg Rev: BProg Rev: B

2-Deburr if necessary

HB 8-5-7(10)PTO

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEHB 8-5-7

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK08/05/08 (10)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

RD/FL08/05/08(10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3303-1 PAR #: N/A Fault Category: Prod / Asst. Med & SNPL NCR: Yes (No) DQA: D Date: 08/05/12
DY12-724 QA: N/C Closed: D Date: 08/05/12

NCR: <u>38971</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.05.02	2	QTY (3) have enlarged holes upto 0.140 0.140. Consecutive holes in row. Root Cause: Waterjet machine requires maintenance	<u>RA</u> QSI 042 08.05.07	SCRAP AND REPLACE. DUE TO POSSIBLE VIBRATION SEE ATTACHED <u>Bk 105555</u>	<u>Bk 105555</u> 08/05/08	<u>08/05/08</u>	<u>RA</u> QSI 042 08.05.07	<u>08/05/08</u>

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 4:16:41 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 38971

Part Number: D33031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



10

Comment: INSPECT CHEMICAL CONVERSION COAT

AS 08-05-08

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 83

AS 08/05/08

10

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

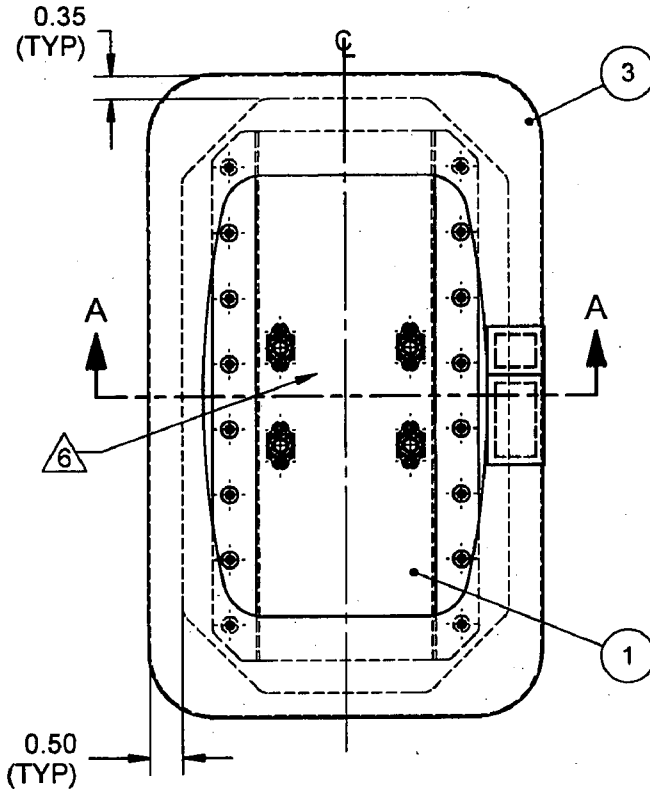
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

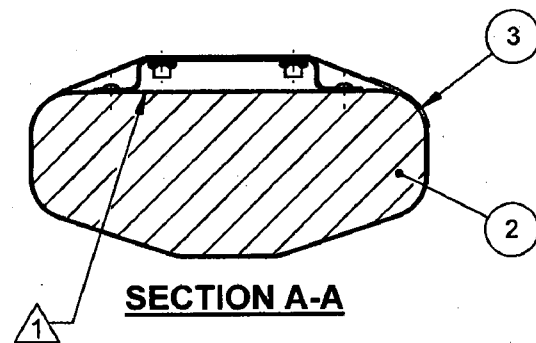


DESIGN <i>PH</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 1 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:3
REV	DATE	DESCRIPTION	
A	04.08.18	NEW ISSUE	
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE	



RELEASED

dc 09.19 *[Signature]*



SECTION A-A

D3303-041 HEAD REST

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

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WORK ORDER
NO. 38971

NOTES:

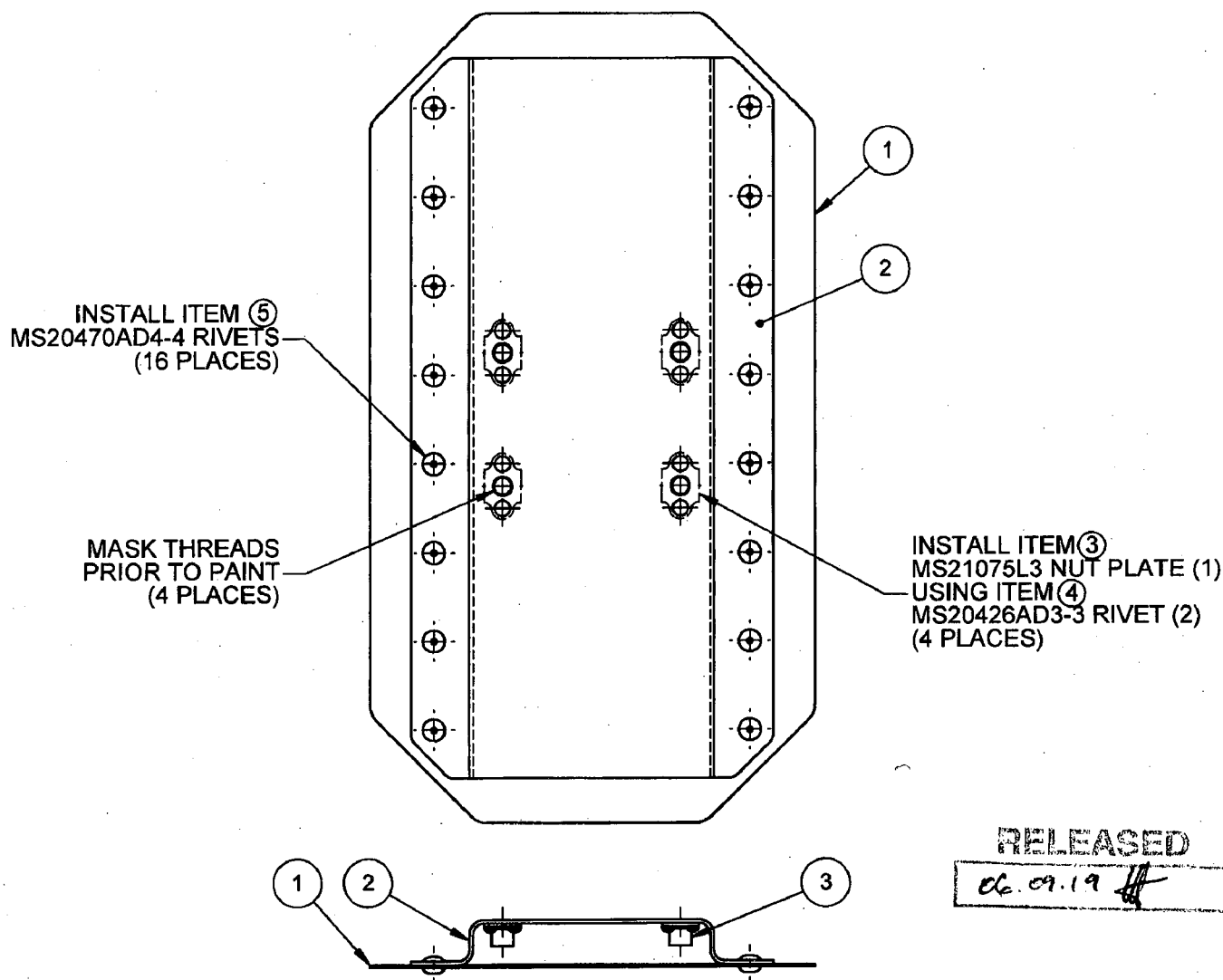
- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACORDDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 2 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



RELEASED

06.09.19 *[Signature]*

D3303-043 BRACKET ASSEMBLY

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

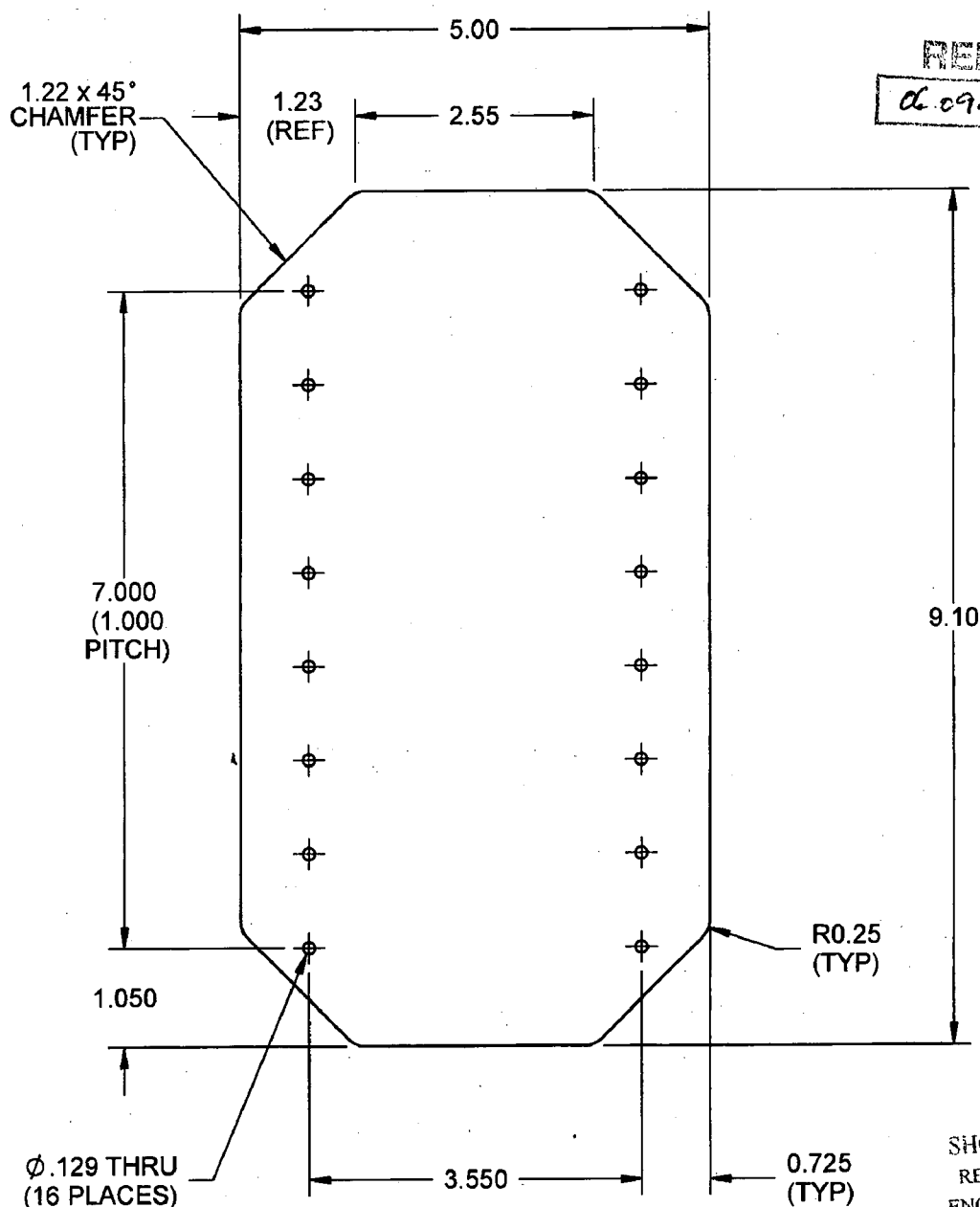
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DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



D3303-1 PLATE

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

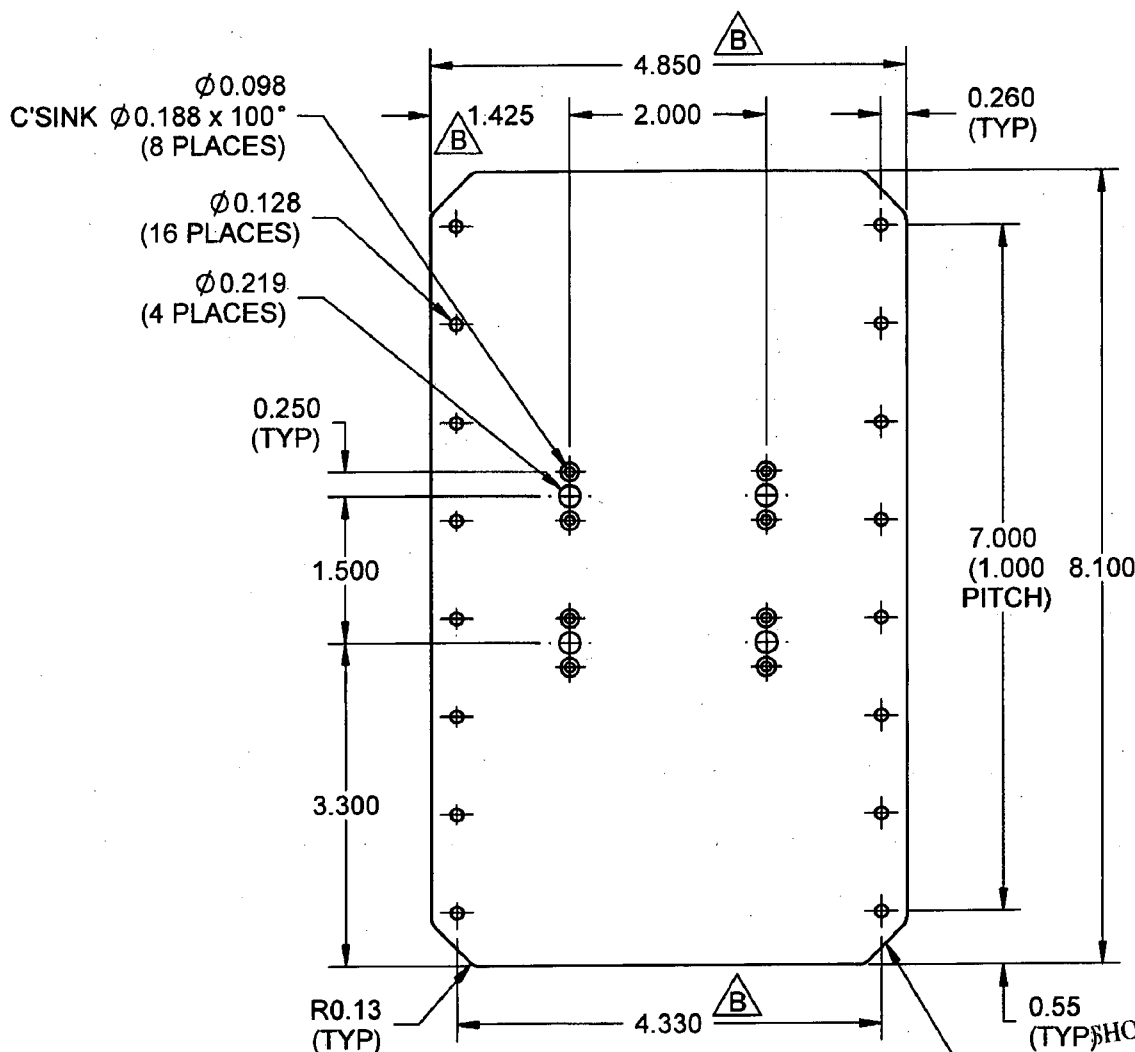
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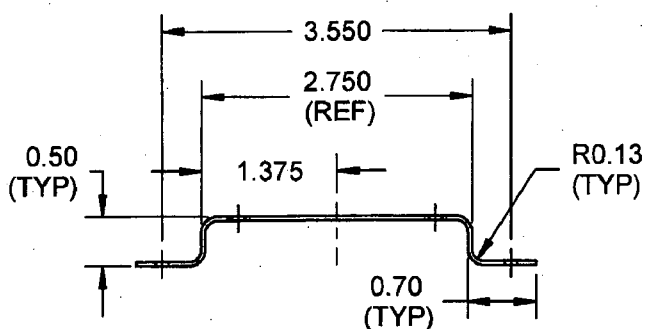
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CHECKED <i>PH</i>	APPROVED <i>BS</i>	DRAWING NO. D3303	REV. B SHEET 4 OF 4
DATE 06.08.17		TITLE HEAD REST SCALE 1:2	



D3303-3F BRACKET FLAT PATTERN



D3303-3 BRACKET BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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Peter Hum

From: David Shepherd [dshepherd@dartaero.com]
Sent: May 7, 2008 3:55 PM
To: 'Peter Hum'
Subject: RE: D3303-1 hole for MS20470AD4 rivet

Peter,

From our discussion, it sounds like its only 4 out of 16 holes that are oversized and that they are randomly scattered about the part.

If this is the case, then these parts are acceptable.

If it had been every hole, then I would have been concerned about the parts becoming loose because of aircraft vibration.

David

From: Peter Hum [mailto:phum@dartaero.com]
Sent: Wednesday, May 07, 2008 7:48 AM
To: 'David Shepherd'
Subject: D3303-1 hole for MS20470AD4 rivet

David,

Production is making a D3303-1 plate on the waterjet. Some of the 0.128" holes for the MS20470AD4 rivet have been elongated to 0.138" in diameter (see attached). This part is for the D3303-041 Head Rest. The 0.138" hole is outside the tolerance of 0.128" holes.

Is this deviation acceptable?

FYI – Eric Downing has indicated to me that waterjet is in need of maintenance (parts on order) and that is why we are getting some of the holes for flat patterns elongated. This sort of deviation is a temporary problem.

Peter

No virus found in this incoming message.

Checked by AVG.

Version: 7.5.524 / Virus Database: 269.23.9/1417 - Release Date: 5/6/2008 8:07 AM

No virus found in this outgoing message.

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Version: 7.5.524 / Virus Database: 269.23.9/1419 - Release Date: 5/7/2008 7:46 AM

07/05/2008